

Work Order ID 57611-1

Friday, April 09, 2010 2:44:09 PM



Page 1

Item ID: D4016-1

Revision ID:

Item Name: Hinge Half, Base

Start Date: 4/12/2010

Start Qty: ~~12.00~~ 2

Required Date: 4/13/2010

Req'd Qty: ~~12.00~~ 2

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *mf*

Date: *10-4-9*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4016

A

100



Bandsaw

Jeaspa Bandsaw

Cut blanks as per folio

0.00

Memo

CUT BLANK 1.00" LONG

0.00

mf 10/04/10

12 P

110



HAAS I

HAAS CNC vertical machine #1

0.00

Memo

MACHINE AS PER FOLIO FA869 AND DWG
FOLIO REV: *AF*
DWG REV: *AF*

0.00

mf 10.4.13

(2)

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57611

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Page 2

Item ID: D4016-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Half, Base

Stop



Start Date: 4/12/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

uf 10.4.13

2

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SP 10/04/13

2 0

160

Identify as per dwg & Stock Location: *Berkel*

0.00



Packaging

Memo

0.00

Packaging

2 PD 10.04.13

W/O:		WORK ORDER CHANGES					
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Work Order ID 57611

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Page 3

Item ID: D4016-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Half, Base

Stop



Start Date: 4/12/2010 Start Qty: 12.00

Required Date: 4/13/2010 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/15
MF
10-4-14

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, April 09, 2010 2:44:08 PM

Page 1

Work Order ID: 57611

Parent Item: D4016-1

Parent Item Name: Hinge Half, Base


Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Start Date: 4/12/2010

Required Date: 4/13/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	16.3000	1.0105			
												
304 bar 1.50 X1.50												

Warehouse

Location

Main Warehouse

MAT54

108381

112752

Loc Qty

16.3

12

4.3

Loc Code

1.0105 and 10/04/10

W/O:		WORK ORDER CHANGES					
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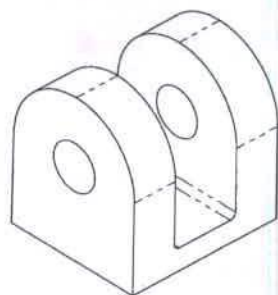
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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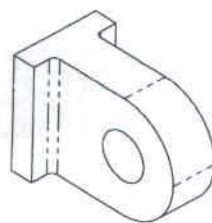
NOTE: Date & initial all entries

Value stream mapping

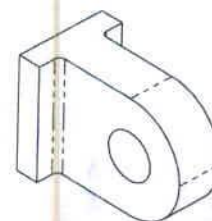
- Value stream mapping is **the best way to identify where the high payoff** opportunities are, yet value stream mapping is the lean tool most likely to **not be used by** companies doing pretend lean!



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

RELEASED
2010-02-16

A		NEW ISSUE		JFH	10.01.29
REV		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 2	
CHECKED	<i>[Signature]</i>	DRAWING NO.		REV. A	
MFG. APPR.	<i>[Signature]</i>	D4016		SCALE	
APPROVED	<i>[Signature]</i>	TITLE		NTS	
DE APPR.	<i>[Signature]</i>	BASKET HINGE			
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

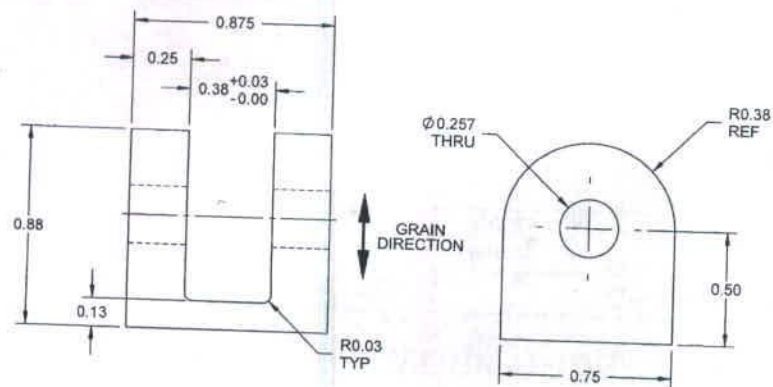
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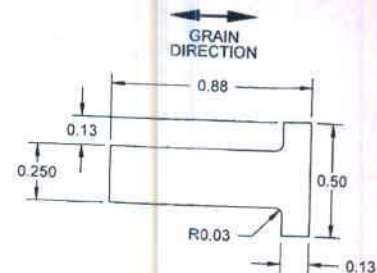
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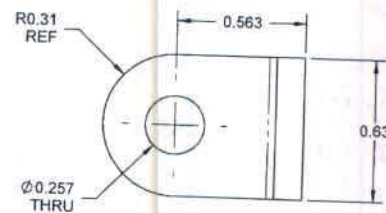
NOTE: Date & initial all entries



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

NOTES:

- 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4180)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	SHEET 2 OF 2
MFG. APPR.	<i>[Signature]</i>	D4016	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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